

Work Order ID 69383

Tuesday, May 10, 2011 1:40:01 PM



Page 1

Item ID: DSI 9464-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Tuning

Start Date: 5/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3955	A								
DSI 9464	B								

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP DSI 9464-011
CHG001

Substio

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

15/10/11

Work Order ID 69383

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Item ID: DSI 9464-011

Accept

Revision ID:

Item Name: Skidtube Tuning

Start Date: 5/10/2011 Start Qty: 2.00

Required Date: 5/10/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

130

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9464-011

Location: 20PPP rev: A

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



(72)

11/5/10

11/5/10

11/5/10

Picklist Print

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Page 1

Work Order ID: 69383

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning



Start Date: 5/10/2011

Required Date: 5/10/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
per ECN10-553 DD 10.04.19 verified byEC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3955-041		Manufactured	No			110	Each	9.0000	2	4			
8 +2 Doubler Assembly													

Location	Loc Qty	Loc Code
ST098	9	
68216	3	
69048	6	

D3955-3		Manufactured	No			110	Each	6.0000	2	4			
826 Cover Plate													

Location	Loc Qty	Loc Code
ST097	6	
68218	2	
69049	4	

D3955-5		Manufactured	No			110	Each	11.0000	2	4			
632 Plate													

Location	Loc Qty	Loc Code
ST097	11	
68219	3	
69050	8	

Picklist Print

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Work Order ID: 69383

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 5/10/2011

Required Date: 5/10/2011

Start Qty: 2.00

Required Qty: 2.00

D3955-7

Manufactured No

110

Each

19.0000

6

12



Plate

Location

Loc Qty

Loc Code

ST098

19

~~68220~~

2

69051

17

D3955-21

Manufactured No

110

Each

8.0000

2

4



Gasket

Location

Loc Qty

Loc Code

ST098

8

67410

8

D3955-23

Manufactured No

110

Each

6.0000

2

4



Template

Location

Loc Qty

Loc Code

ST098

6

68217

2

69052

4

CR3212-4-04

Purchased No

110

Each

551.0000

38

76



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

551

115698

151

116471

400

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Shop Packet Print

Picklist Print

Tuesday, May 10, 2011 1:39:59 PM

Work Order ID: 69383

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 5/10/2011

Required Date: 5/10/2011

Start Qty: 2.00

Required Qty: 2.00

AN3-5A
Bolt

Purchased No 110 Each 1,180.000 4



8

Location

Loc Qty

Loc Code

ST350

1180

115371

380

117423

800

8

AN3-6A
Bolt

Purchased No 110 Each 404.0000 4



8

Location

Loc Qty

Loc Code

ST351

404

116191

4

~~116704~~

100

117441

300

6

AN3-7A
Bolt

Purchased No 110 Each 66.0000 4



8

Location

Loc Qty

Loc Code

ST351

66

117313

66

8

AN3-10A
Bolt

Purchased No 110 Each 85.0000 4



115110 2x

Location

Loc Qty

Loc Code

ST351

85

117313

85

8

Picklist Print

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Work Order ID: 69383

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning



Start Date: 5/10/2011

Required Date: 5/10/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Purchased

No

110

Each

2,716.000

6

12



Washer



SP

Location

Loc Qty

Loc Code

ST297

2000

117087

2000

ST298

716

117291

716

MS21042L3

Purchased

No

110

Each

2,359.000

2



Nut



12
4
11/5/10 SP (2)

Location

Loc Qty

Loc Code

ST300

2359

116391

11

116540

382

116549

766

117441

800

117601

400

4

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REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND:

INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER,
INSTALLATION INSTRUCTIONS D204-635 REV. F OR EARLIER,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER,
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D204-635 REV. 3 OR EARLIER

REF CANADIAN STC: SH96-88
REF FAA STC: SR00563NY
REF EASA STC: EASA.IM.R.S.01303

Purpose:

The Purpose of the DSI 9464-011 Kit is to allow operators to tune landing gear utilizing D205-634-041 / D204-635-041 skid tubes in order to eliminate vibration. This kit consists of various weights that can be attached to the fwd cap of the Dart skid tube.

Procedure:

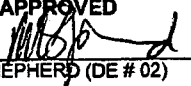
Note: Installer must be careful not to damage underlying skid tube during drilling operations.






- 1) Locate D3955-23 template on the fwd cap of the skid tube. Transfer drill 19 x Ø0.098" holes from the D3955-23 template to the skid tube cap using a #30 drill.
- 2) Transfer drill 1 x Ø0.625" (15.8 mm) from the D3955-23 template to the skid tube as shown in Figure 1.
- 3) Transfer drill 1 x Ø0.201" (#7 drill) from the D3955-23 template to the skid tube as shown in Figure 1.
- 4) Deburr the drilled holes in fwd cap. Ensure the top surface of the cap is clear of debris.
- 5) Apply a layer of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant between the D3955-041 Doubler and the existing skid tube cap. Install D3955-041 Doubler Assy. using 19 x CR3212-4-04 rivets as shown in Figure 1. The nutplate in the D3955-041 Doubler Assy should pass thru the Ø0.625 hole in the cap.
- 6) Install tuning plates as shown in Figure 2. Torque AN3 bolts 15-25 in-lb (1.7-2.8 N-m). Test the landing gear for vibration.
- 7) If vibration persists, repeat step 6 until vibration is eliminated.
- 8) Update Weight & Balance as outlined below.

Weight And Balance:

The weight and balance increase associated with the installation of the DSI 9464-011 kit will depend on the number of plates that are installed to tune the gear. The weight of individual plates are given in the Parts List Table. The longitudinal arm for the installation of the DSI 9464-011 kit is 40.0 in (1.02 m) on 205/210/212/214/412 models and 42.0 in (1.07 m) on 204 models.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

B	ADD REF TO D204-635	CP	10.04.14
A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9464	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	10.04.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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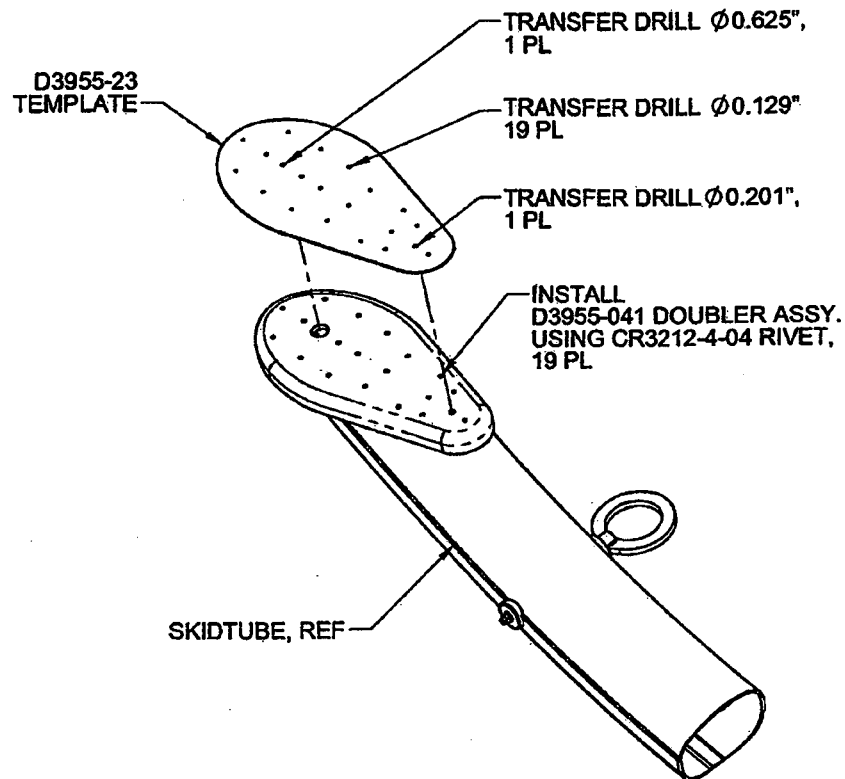






Figure 1

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9464	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	10.04.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

REFERENCE ONLY

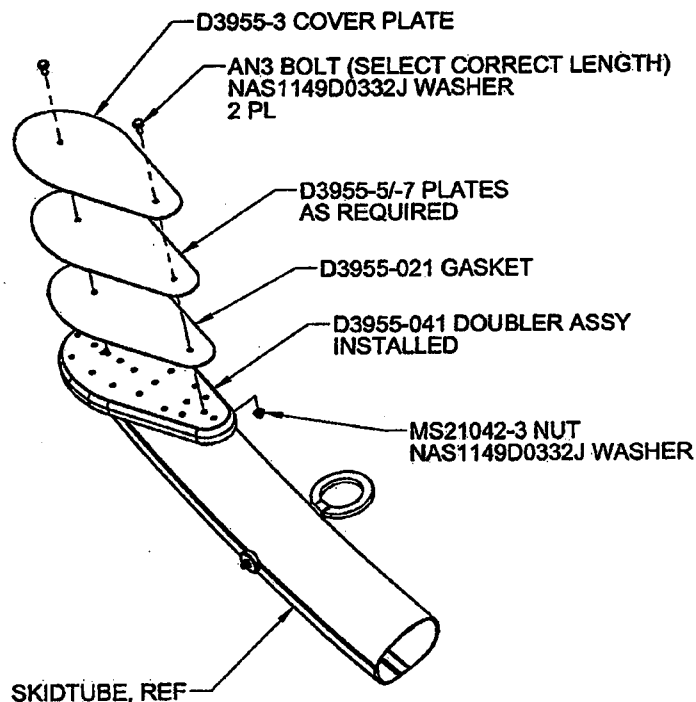


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	<i>gp</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>N/A</i>	DSI 9464	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
DATE	10.04.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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